

7355



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBEM632V3021132-1
Job Sheet 180235



LS # 4

7
DAG
21
29

6/5

Part No: RBEM632V3021132-1

Job Qty: 6 ea

Part Name: Unthreaded Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/3/18

Job Tracking No:

Due Date: 8/13/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBEM632V3021132 Rev. 2 IPP Rev. A 18.06.27 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
90	Start up Operation	6 Ea	8/13/18	8/13/18	0.00	0.00	Start Up Machining-4		DAS 564
120	Mori Seiki	6 pcs	8/13/18	8/13/18	0.00	1.50	MORI SL2500Y		PMP 2018-10-09
130	QC	6 pcs	8/13/18	8/13/18	0.00	0.00	QC2 Machining-5		
160	QC	6 pcs	8/13/18	8/13/18	0.00	0.00	QC8 Machining-5		
170	Outsource	6 pcs	8/13/18	8/13/18	0.00	0.00	Outsource13	P/O: 041279	OCT 09 2018
180	Packaging	6 pcs	8/13/18	8/13/18	0.00	0.00	Packaging2		OCT 17 2018
190	QC	6 pcs	8/13/18	8/13/18	0.00	0.00	QC6		38
200	Powdercoat	6 pcs	8/13/18	8/13/18	0.00	0.60	Powdercoat13		BR 18-10-18
210	QC	6 pcs	8/13/18	8/13/18	0.00	0.00	QC3		OCT 17 2018
220	Small Fab	6 pcs	8/13/18	8/13/18	0.00	0.50	Small Fab-9		MLL DAS 9-89
230	QC	6 pcs	8/13/18	8/13/18	0.00	0.00	QC5		38
240	Packaging	6 pcs	8/13/18	8/13/18	0.00	0.00	Packaging3-2		MLL DAS 9-89
250	QC21-SA	6 Ea	8/13/18	8/13/18	0.00	0.00	QC21		OCT 22 2018

Part Op 120 - 1-Machine as per folio FC217 FOLIO REV: AA DWG REV: 2 2-Deburr 9-89
 Descriptions: 170 - Issue P/O to GROUPE ALTECH: P/O 170:041279 -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material
 type; 1018 -Certificate of Conformity is required
 180 - Receive 1:30
 200 - START TIME: 1:30 OVEN TEMPERATURE: 320° FINISH TIME: 2:00 No powder coat at
 this location as per note 3.
 220 - Laser engrave P/N as per DWG.
 240 - IDENTIFY AND STOCK

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M1018R2.750	M1018R2.750	.4980 ft (.083 ea)	90-Start up Operation	5098041

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CANADA

TEL.: 1 613 632-5200

Email: sales@dartaero.com

www.dartaerospace.com



Container No: S115937



Part: RBEM632V3021132-1

Job No: 180235

Serial No/Batch: S115937

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 10/04/18

ns

Required	Inventory	Allocated
0	6	0

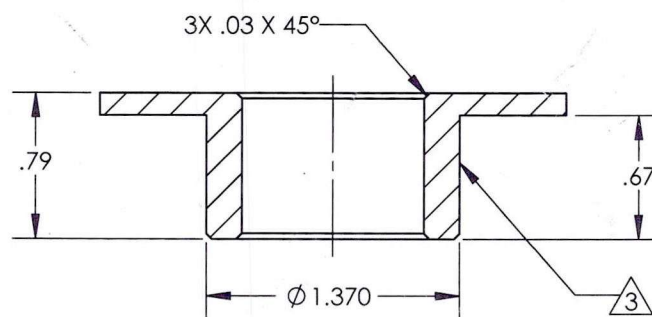
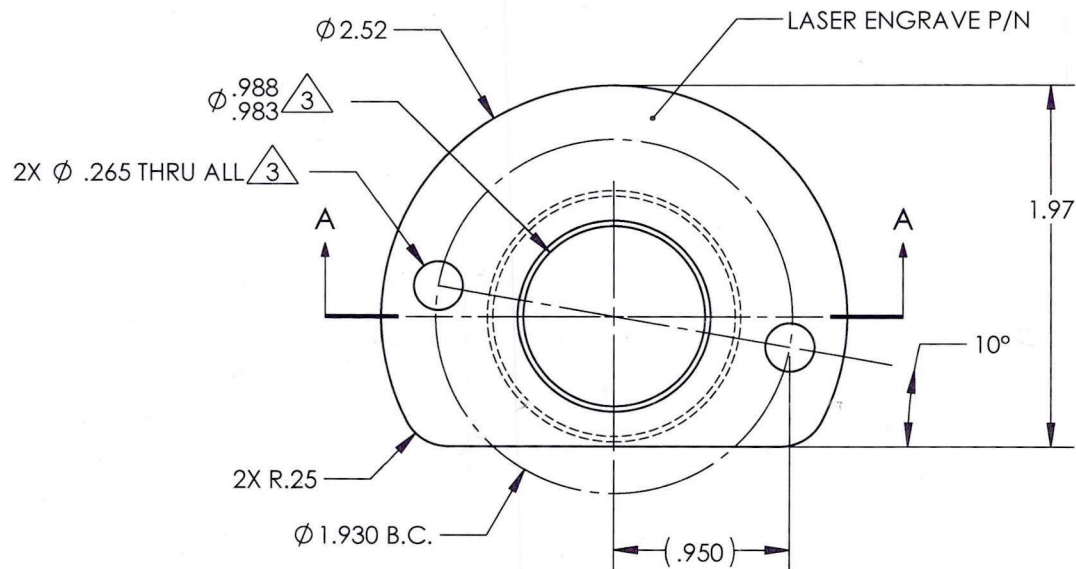
Plex 10/1/18 4:16 PM dart.logan.david

Part Specifications
Specifications could not be found.

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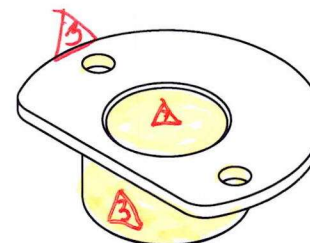
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0014	-1 DELETED INK STAMP T/N, S/N. ADDED LASER ENGRAVE P/N.	1/24/2017	RJC	JAG



SECTION A-A

(-1)

UNTHREADED PLATE



NOTES:

1. ZINC PLATE SPEC. ASTM B633 TYPE I.
2. POWDER COAT YELLOW SPEC. FED # 13538.
3. NO POWDER COAT ON SURFACE.

DART AEROSPACE	
TITLE NUT KEY	
DWG NO. RBEM632V3021132-1	REV 2
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX $\pm .005$ FRACTIONS $\pm 1/8$
FINISH SEE NOTES	.XX $\pm .01$ ANGLES $\pm 5^\circ$
SPEC	.X $\pm .1$ SURFACES = 125/
DRAWN BY: MACKOVJAK	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	H175
SCALE 1:1	DATE 3/3/2016
SHEET 2 OF 4	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



Dart Aerospace Ltd.
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PURCHASE ORDER **PO041279**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO041279
PO Date: 10/9/18
Due Date: 10/17/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lavoie, Chantal
Phone: clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	180235	RBEM632V3021132-1	Unthreaded Plate -Issue P/O to GROUPE ALTECH: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 1018 -Certificate of Conformity is required	Firmed	-	10/17/18	7 pcs	0 pcs	7 pcs	\$1.76471/pcs	\$12.35
2	180217	RBEM632V3021125-3	Jaw -Issue P/O to GROUPE ALTECH: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 4140 -Certificate of Conformity is required	Firmed	-	10/17/18	24 pcs	0 pcs	24 pcs	\$1.76471/pcs	\$42.35

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38
9-89



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PURCHASE ORDER **PO041279**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	180236	RBEM632V3021132-3	Threaded Plate -Issue P/O to GROUPE ALTECH: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 1018 -Certificate of Conformity is required	Firmed	-	10/17/18	6 pcs	0 pcs	6 pcs	\$1.7647058/pcs	\$10.59
							6x			OCT 12 2018	
4	180219	RBEM632V3021125-7	Bolt -Issue P/O to GROUPE ALTECH: P/O -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 1018 -Certificate of Conformity is required	Firmed	-	10/17/18	10 pcs	0 pcs	10 pcs	\$1.76471/pcs	\$17.65
							10x			OCT 12 2018	
5	180241	RBEM632V3021221-1	Guide -Issue P/O to GROUPE ALTECH: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 1018 -Certificate of Conformity is required	Firmed	-	10/17/18	10 pcs	0 pcs	10 pcs	\$1.76471/pcs	\$17.65
							10x			OCT 12 2018	
Grand Total:											\$100.59



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PURCHASE ORDER PO041279

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

CL

Plex 10/12/18 1:14 PM dart.lavoie.chantal



Certificat de Conformité / Certificate of Compliance

(013368-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

013368- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
11-Oct-2018		Jessie Boisvert		041279				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Quantités / Quantities				
				Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBEM632V3021132-1 Rev.	RBEM632V3021132-1 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS TYPE 1 SC2	ZINC CH	7	1	0	0	0
2	RBEM632V3021125-3 Rev.	RBEM632V3021125-3 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS TYPE 1 SC2	ZINC CH	24	24	0	0	0
3	RBEM632V3021132-3 Rev.	RBEM632V3021132-3 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS TYPE 1 SC2	ZINC CH	6	6	0	0	0
4	RBEM632V3021125-7 Rev.	RBEM632V3021125-7 TYPE 2 SC2	ZINC CH	10	10	0	0	0
5	RBEM632V3021221-1 Rev.	01 - ZINC-YELLOW TRI ASTM [ZINC-YELLOW TRIVALENT ASTM] RBEM632V3021221-1 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS TYPE 1 SC2	ZINC CH	10	10	0	0	0

 DAS
 38
 9-89

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Notons certifierons que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.